

010701



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada
Tel (613) 632-5200
Fax 613 632-5246

Deviation

C3
Job Sheet 194631



Part No: C3 Job Qty: 1 pcs
Part Name: C-Series Remote Hook 3,000 lbs Lift Capacity

Order 15552

Part Weight: 0 lbs Status: New Priority: Medium
Job Created: 5/6/19 Job Tracking No:
Due Date: 6/21/19 Created By: Jennifer Renwick
Type: SOLD Description:
Note: DWG C3 Rev 2 IPP Rev A 18.03.29 New issue DP Verify DD
Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	Sign-off
95	External Load - 1	1 pcs	6/21/19	6/21/19	0.00	1.00	External Load - 1		AP
							External Load - 2		
							External Load - 3		
100	External Load - 2 - B4B	1 pcs	6/21/19	6/21/19	0.00	1.00	External Load - 1 - B4B		AP 2019/07/05
							External Load - 2 - B4B		
							External Load - 3 - B4B		
110	QC 5	1 pcs	6/21/19	6/21/19	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		DAS
							QC 5 - 30		30
							QC 5 - 40		9-89
120	DC - 1 - B4B	1 pcs	6/21/19	6/21/19	0.00	0.00	DC - 1 - B4B		DAS
							DC - 2 - B4B		21
130	Packaging 3-2 - Stock - B4B	1 pcs	6/21/19	6/21/19	0.00	0.00	Packaging 3 - 1 - B4B		9-88
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		
							Packaging 3 - 7 - B4B		
							Packaging 3 - 8 - B4B		68-6
							Packaging 3 - 9 - B4B		08
							Packaging 3 - 10 - B4B		9-88
							Packaging 3 - 11 - B4B		
							Packaging 3 - 12 - B4B		
							Packaging 3 - 13 - B4B		
							Packaging 3 - 14 - B4B		
							Packaging 3 - 15 - B4B		
							Packaging 3 - 16 - B4B		
							Packaging 3 - 17 - B4B		

Do a move inventory to Qc-?

SN 986780

JUL 05 2019

JUL 05 2019

JUL 05 2019

DART
AEROSPACE
Container No: S186780
Part: C3
Job No: 194631
Serial No/Batch: S186780
Revision: 2
Inspector:
Exp Date:
Instructions:
Date: 06/04/19

				Packaging 3 - 18 - B4B		
				Packaging 3 - 19 - B4B		
				Packaging 3 - 20 - B4B		
				Packaging 3 - 21 - B4B		
				Packaging 3 - 22 - B4B		
				Packaging 3 - 23 - B4B		
				Packaging 3 - 24 - B4B		
				Packaging 3 - 25 - B4B		
				Packaging 3 - 26 - B4B		
				Packaging 3 - 27 - B4B		
				Packaging 3 - 28 - B4B		
				Packaging 3 - 29 - B4B		
				Packaging 3 - 30 - B4B		
				Packaging 3 - 31 - B4B		
				Packaging 3 - 32 - B4B		
				Packaging 3 - 33 - B4B		
				Packaging 3 - 34 - B4B		
				Packaging 3 - 35 - B4B		
Packaging 3 - 36 - B4B						
140	QC 21 - SA	1 pcs	6/21/19	0.00 0.00	QC 21 - SA - 21	DAG
					QC 21 - SA - 70	21
					QC 21 - SA - 53	9-25
Part Op 95 - (Small Fab) 1- PICK C3-2-1 AND LASER ENGRAVE AS PER DWG . SEE NOTE 3 AND 4 ON SHEET 3. 2- Descriptions: ASSEMBLE AS PER DWG 100 - (Small Fab) 1- PICK C3-2-1 AND LASER ENGRAVE AS PER DWG . SEE NOTE 3 AND 4 ON SHEET 3. 2- ASSEMBLE AS PER DWG 110 - QC5- Inspect part completeness to step on W/O) 120 - (Document Control)- Photocopy blue file OM & OOPM-C3 Rev 4 130 - Identify as per dwg & Stock Location: _____)Identify and Stock 140 - (QC21- Final Inspection - Work Order Release)						

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
188-FPSS-1032-1/4	Set Screw	2 Ea (2 ea)	95-External Load - 1	S110495
188-FSCS-832-5/8	Clock Spring Cover Screw	4 Ea (4 ea)	100-External Load - 2 - B4B	S189728
2595K22	Heat Shrink Tube	1 pcs (1 ea)	100-External Load - 2 - B4B	S058857
32446	Crimp Terminal	2 Ea (2 ea)	100-External Load - 2 - B4B	S074909
8183K6	Wire Guide/Grip	1 Ea (1 ea)	100-External Load - 2 - B4B	S118247
AN4-16A	Bolt	3 Ea (3 ea)	100-External Load - 2 - B4B	S157301-3
AN4-17A	Bolt	1 Ea (1 ea)	100-External Load - 2 - B4B	S157429-3
AN6-15A	Bolt	1 Ea (1 ea)	100-External Load - 2 - B4B	S068641
C2-1-1	Manual Release Knob	1 pcs (1 ea)	100-External Load - 2 - B4B	S068051
C2-10-1	Lock Spring Pin	1 pcs (1 ea)	100-External Load - 2 - B4B	S157074
C2-11-2	Locating Pin	2 Ea (2 ea)	100-External Load - 2 - B4B	S061528
C2-3-1	Latch Shaft Du Bearing	2 pcs (2 ea)	100-External Load - 2 - B4B	S177832
C2-3-10	Latch Shaft	1 pcs (1 ea)	100-External Load - 2 - B4B	S068051 S180410
C2-3-11	Actuator	1 pcs (1 ea)	100-External Load - 2 - B4B	S174393
C2-3-2	Latch Roller Pin	1 pcs (1 ea)	100-External Load - 2 - B4B	S173563
C2-3-2-1	Roller Pin Retaining Ring	2 Ea (2 ea)	100-External Load - 2 - B4B	S168898
C2-3-3	Latch Roller	1 pcs (1 ea)	100-External Load - 2 - B4B	S116487
C2-3-3-1	Latch Roller DU Bearing	1 pcs (1 ea)	100-External Load - 2 - B4B	S120788
C2-3-5	Spacer, Teflon	2 Ea (2 ea)	100-External Load - 2 - B4B	S111642
C2-3-6	Latch	1 pcs (1 ea)	100-External Load - 2 - B4B	S083629
C2-3-8	Actuator Shaft Bushing	2 pcs (2 ea)	100-External Load - 2 - B4B	S178019
C2-5-1	Actuator Stop	1 Ea (1 ea)	100-External Load - 2 - B4B	S072964
C3-10-2	Lock Spring	1 pcs (1 ea)	100-External Load - 2 - B4B	S080352
C3-11-1	Side Plate - Solenoid C3-Hook	1 pcs (1 ea)	100-External Load - 2 - B4B	S182333
C3-12-1	Lock Bushing	2 pcs (2 ea)	100-External Load - 2 - B4B	S181364
C3-12-2	Lock Shaft - C3 Hook	1 pcs (1 ea)	100-External Load - 2 - B4B	S080193
C3-12-3	Lock - C3 Hook	1 pcs (1 ea)	100-External Load - 2 - B4B	S029266
C3-12-4	Lock Roller	1 pcs (1 ea)	100-External Load - 2 - B4B	S100620
C3-12-5	Lock Roller Pin	1 pcs (1 ea)	100-External Load - 2 - B4B	S100174
C3-12-6	Lock Roller Pin Circlip	2 Ea (2 ea)	100-External Load - 2 - B4B	S157956
C3-13-1	Keeper Bushing	2 pcs (2 ea)	100-External Load - 2 - B4B	S029270
C3-13-4	KEEPER	1 pcs (1 ea)	100-External Load - 2 - B4B	S029271
C3-13-5	Spring, Keeper	1 pcs (1 ea)	100-External Load - 2 - B4B	S089547
C3-2-1	Side Plate C-3 Hook	1 pcs (1 ea)	100-External Load - 2 - B4B	S175253
C3-3-4	Link Pin	2 pcs (2 ea)	100-External Load - 2 - B4B	S118503
C3-3-4-1	Ring, Retaining	4 pcs (4 ea)	100-External Load - 2 - B4B	S189530
C3-3-7	Link	1 pcs (1 ea)	100-External Load - 2 - B4B	S048390
C3-3-9	Actuator Spring	1 pcs (1 ea)	100-External Load - 2 - B4B	S128685
C3-4-1	Load Beam Bushing	2 pcs (2 ea)	100-External Load - 2 - B4B	S180767
C3-4-1A	C3 Load Beam Assy	1 pcs (1 ea)	100-External Load - 2 - B4B	S179604
C3-7-1	Load Beam Bumper	1 pcs (1 ea)	100-External Load - 2 - B4B	S186739
C3-7-2	Lock Bumper	2 pcs (2 ea)	100-External Load - 2 - B4B	S120071
C3-8-2	Solenoid	1 pcs (1 ea)	100-External Load - 2 - B4B	S137893
C3-8-4	Solenoid Cover Gasket	1 pcs (1 ea)	100-External Load - 2 - B4B	S180680
C3-8-5	Solenoid Cover	1 pcs (1 ea)	100-External Load - 2 - B4B	S153419
C3-9-1	Clock Spring Cover - C3 Hook	1 pcs (1 ea)	100-External Load - 2 - B4B	S029289
C3-9-2	Spring, Clock	1 pcs (1 ea)	100-External Load - 2 - B4B	S089524
EL-PLUG-M	3-Prong Male Spade Plug	1 Ea (1 ea)	100-External Load - 2 - B4B	S176126
M27500-16TG2T14	Wire - 16-Gauge - Shielded	1 ft (1 ea)	100-External Load - 2 - B4B	S075144
MS21044N4	Nut, Self-Locking	4 Ea (4 ea)	100-External Load - 2 - B4B	S119541
MS21083N3	Nut	2 Ea (2 ea)	100-External Load - 2 - B4B	S142051
MS21083N6	Nut	1 Ea (1 ea)	100-External Load - 2 - B4B	S180294
MS35266-63	Solenoid Cover Screw	1 Ea (1 ea)	100-External Load - 2 - B4B	S078256
MS35266-63	Solenoid Cover Screw	1 Ea (1 ea)	100-External Load - 2 - B4B	
NAS1149F0332P	Washer	2 Ea (2 ea)	100-External Load - 2 - B4B	S103666-1
NAS1149F0363P	Washer	1 Ea (1 ea)	100-External Load - 2 - B4B	S027738
NAS1149F0463P	Washer	8 Ea (8 ea)	100-External Load - 2 - B4B	S097088-4
NAS1149F0632P	Washer	2 Ea (2 ea)	100-External Load - 2 - B4B	S137711
7856K75	SHRINK TUBE 6"			S190246

MS21083-N3

GREASE AEROSHELL No. 7 (M138964)
LOCTITE 620 (S166705)
SAF-T-ELE (M128063)

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
95-External Load - 1	188-FPSS-1032-1/4	2	192	0
	188-FSCS-832-5/8	4	107	0
100-External Load - 2 - B4B	2595K22	1	35	0
	32446	2	704	0
	8183K6	1	34	0
	AN4-16A	3	348	0
	AN4-17A	1	460	0
	AN6-15A	1	19	0
	C2-1-1	1	8	0
	C2-10-1	1	74	0
	C2-11-2	2	56	0
	C2-3-1	2	70	0
	C2-3-10	1	3	0
	C2-3-11	1	26	0
	C2-3-2	1	27	0
	C2-3-2-1	2	94	0
	C2-3-3	1	50	0
	C2-3-3-1	1	24	0
	C2-3-5	2	67	0
	C2-3-6	1	11	0
	C2-3-8	2	50	0
	C2-5-1	1	12	0
	C3-10-2	1	24	0
	C3-11-1	1	2	0
	C3-12-1	2	29	0
	C3-12-2	1	27	0
	C3-12-3	1	8	0
	C3-12-4	1	32	0
	C3-12-5	1	7	0
	C3-12-6	2	50	0
	C3-13-1	2	36	0
	C3-13-4	1	7	0
	C3-13-5	1	101	0
	C3-2-1	1	21	0
	C3-3-4	2	22	0
	C3-3-4-1	4	120	0
	C3-3-7	1	20	0
	C3-3-9	1	59	0
	C3-4-1	2	1	0
	C3-4-4A	1	9	0
	C3-7-1	1	12	0
	C3-7-2	2	44	0
	C3-8-2	1	12	0
	C3-8-4	1	10	0
	C3-8-5	1	15	0
	C3-9-1	1	18	0
	C3-9-2	1	38	0
	EL-PLUG-M	1	55	0
	M27500-16TG2T14	1	49	0
	MS21044N4	4	116	0
	MS21083N3	2	122	0
	MS21083N6	1	9	0
	MS35266-63	2	28	0
	NAS1149F0332P	2	5,135	0
	NAS1149F0363P	1	437	0
	NAS1149F0463P	8	466	0
	NAS1149F0632P	2	387	0
Part Specifications				
Specifications could not be found.				

Plex 5/6/19 3:53 PM Dart.Renwick.Jennifer



Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: <u>194631</u>		DISPOSITION		DEPARTMENT/PROCESS				Completed By	
Part No. <u>C3 Rev. 2</u>		Rework ☐ Scrap ☐ Use-as-is ☐		Skid-tube ☐ Machining ☐ Large Fab ☐		Cross tube ☐ Small Fab ☐ Finishing ☐		Eng. (Non-AW) ☒ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐	
Date: <u>July 3, 2014</u>	Sequence #:	QTY Affected:		Disposition				MRE (QS1042) <u>WJP</u>	
Description Work Order Deviation		This deviation is acceptable. The fit, form, and function is as originally intended.						QC / QA Coordinator	
Root Cause		FAULT CATEGORY							
Operator Manufacturing Process Equip/Tooling Handling/Preservation Material Product Improvement Process Improvement Human Factors		Pressure/Forced Bending Crushing Cracks Crimp/Kink/Ripple/Wave/Twist Marks/Chatter Mislabeled Contamination Misaligned/off center BOM/Route Broken/Damage/Defect Incomplete/Unclear Instructions Drill Holes Fit/Function Power Loss/Surge Folio/Program Grain Direction Weld Wrong Stock Pulled Out of Sequence Off-set/Set-up Positioned Wrong Outside Tolerance Drawing Finish Part Lost/Missing Misread							
Other/Details:									



Remote Cargo Hook Test Form

C3

MAKE SURE YOU ARE USING THE CORRECT TEST FORM FOR THE CORRECT SOLENOID!

NEW SOLENOID (152951-001)

Work Order 194631Customer 15552Serial Number S 186780Date 2019-7-2

# of Releases	Load (Lbs.)	Release Method	Remarks	Result	Pass/Fail
1	7,500	Static Hold	Hold for two minutes and reduce load to zero	N/A	<u>Pass</u>
10	1,500	Electircal, 25 volts	No "hang ups" permitted	N/A	<u>pass</u>
2	3,000	Electircal, 22 volts	Current shall not exceed 12.8 A <u>9.1</u>	A	<u>Pass</u>
2	2,500	Electircal, 22 volts	Current shall not exceed 12.8 A <u>8.9</u>	A	<u>Pass</u>
2	2,000	Electircal, 22 volts	Current shall not exceed 12.8 A <u>8.8</u>	A	<u>pass</u>
2	1,500	Electircal, 22 volts	Current shall not exceed 12.8 A <u>8.8</u>	A	<u>Pass</u>
2	500	Electircal, 22 volts	Current shall not exceed 12.8 A <u>8.7</u>	A	<u>Pass</u>
1	3,000	Electircal, 20 volts	Current shall not exceed 11.6 A <u>7.9</u>	A	<u>Pass</u>
1	3,000	Electircal, 28 volts	Current shall not exceed 16.2 A <u>11.2</u>	A	<u>Pass</u>
1	3,000	Manual		N/A	<u>Pass</u>
1	3,000	Impact Test	Impact shackle 10x , shall not release	N/A	<u>Pass</u>
1	N/A	Solenoid Ohms	Shall not exceed 1.7-2.0 Ω <u>2.0</u>	Ω	<u>Pass</u>
1	N/A	Electircal Continuity	Across both wires	N/A	<u>Pass</u>

Test Conducted By:

Michael Palumbo

Technician

Submit

Signature:

Sylvia Sanchez
QC 5 Small FAB / QA